

Date: Thursday, 23/10/2008 10:54:06 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 206/OH-58 SADDLE, INBOARD, LEFT SIDE
Job Number : 42886	
Estimate Number : 12925	
P.O. Number :	Part Number : D29331UP
This Issue : 23/10/2008 S.O. No. :	Drawing Number : D2933 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : C
Previous Run : 41722	Material :
Written By :	Due Date : 15/11/2008 Qty: 10 Um: Each
Checked & Approved By : <u>JLD 08-10-23</u>	
Comment : Est Rev:A New Issue 07-07-04 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101001	Saddle Billet
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)
 Issue material from stock: 7075-T7351 QQ-A-250/12
 Cut Size 2.0 x 6.25 X 6.00
 Grain Along Long 6.00 Length
 Batch No: B 34872

J.L 08/11/07

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Program part number and batch number.
 1-Inspect part number and batch number are programmed correctly.
 2-Machine Step No 1 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet
 3-Machine Step No 2 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet
 4-Machine Step No 3 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet
 5-Deburr

J.L 08/11/07

(10)

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE
 Machine Keyway and inspect per attached dimension sheet

J.L 08/11/08

(10)

4.0	QC1	INSPECT ALL DIM TO DIM SHEET
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Comment: INSPECT ALL DIM TO DIM SHEET

J.L 08/11/07

(10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 23/10/2008 10:54:06 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, LEFT SIDE

Job Number: 42886

Part Number: D29331UP

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SS 08/11/11

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

MF 08/11/11

(10X)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

08-11-11

(K10)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST423

SS 08/11/12

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/11/13

Job Completion



MF 08-11-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 42884
Description: 206 Saddle, Inboard, Left side		Part Number: D2933-1
Inspection Dwg: D2933	Rev: C	DSK: Rev: Page 1 of 1.

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ **First Article**
☐ **Prototype**

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
A	0.100	0.140		.120	.118	.117	.117	
B	0.100	0.140		.121	.119	.117	.118	
C	0.100	0.140		.120	.118	.119	.117	
D	0.210	0.230		.219	.220	.219	.219	
E	1.245	1.255		1.250	1.250	1.250	1.250	
F	1.245	1.255		1.250	1.250	1.250	1.250	
G	2.495	2.505		2.500	2.500	2.500	2.500	
H	0.510	0.515		.511	.510	.510	.510	
I	1.572	1.582		1.577	1.577	1.577	1.577	
J	2.495	2.505		2.500	2.500	2.500	2.500	
K	0.257	0.262		.258	.258	.258	.258	
L	0.312	0.317		.314	.314	.314	.314	
M	0.235	0.240		.238	.238	.238	.238	
N	0.100	0.140		.108	.112	.112	.113	
O	0.540	0.560		.551	.553	.552	.554	
P	0.490	0.510		.500	.498	.499	.498	
Q	3.715	3.725		3.720	3.720	3.720	3.720	
R	2.470	2.510		2.492	2.492	2.492	2.492	
S	0.240	0.270		.257	.257	.256	.255	
T	0.100	0.180		.140	.140	.140	.140	
U	1.625	1.635		1.630	1.630	1.630	1.630	
V	1.362	1.372		1.367	1.367	1.367	1.367	
W	0.316	0.321		.319	.319	.319	.319	
X	1.125	1.145		1.130	1.132	1.132	1.133	
Y	1.565	1.585		1.579	1.578	1.578	1.579	
Z	0.178	0.198		.188	.188	.188	.188	
AA								
AB								
AC								
AD								
AE								
Accept/Reject								

Measured by: J.L. / JML	Date: 08/11/07
Audited by: RS	Date: 08/11/11
Prototype Approval: N/A	Date: N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	06.10.03	Removed DT8683, DT8686 & DT8690	KJ/JLM	
D	07.03.21	Revised per drawing revision C	KJ/JLM	
E	08.01.16	DT8695 A/B removed from dimension Y	KJ/EC/DD	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD				Work Order: 42880	
Description: 206 Saddle, Inboard, Left side				Part Number: D2933-1	
Inspection Dwg: D2933 Rev: C DSK: Rev:				Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article
 ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
A	0.100	0.140		.117	.117	.118	.118	
B	0.100	0.140		.118	.117	.117	.118	
C	0.100	0.140		.117	.118	.120	.119	
D	0.210	0.230		.219	.218	.220	.220	
E	1.245	1.255		1.250	1.250	1.250	1.250	
F	1.245	1.255		1.250	1.250	1.250	1.250	
G	2.495	2.505		2.500	2.500	2.500	2.500	
H	0.510	0.515		.570	.570	.570	.570	
I	1.572	1.582		1.577	1.577	1.577	1.577	
J	2.495	2.505		2.500	2.500	2.500	2.500	
K	0.257	0.262		.258	.258	.258	.258	
L	0.312	0.317		.314	.314	.314	.314	
M	0.235	0.240		.238	.238	.238	.239	
N	0.100	0.140		.112	.112	.113	.112	
O	0.540	0.560		.551	.551	.551	.550	
P	0.490	0.510		.498	.498	.498	.497	
Q	3.715	3.725		3.720	3.720	3.720	3.720	
R	2.470	2.510		2.492	2.492	2.492	2.492	
S	0.240	0.270		.255	.254	.255	.254	
T	0.100	0.180		.140	.140	.140	.140	
U	1.625	1.635		1.630	1.630	1.630	1.630	
V	1.362	1.372		1.367	1.367	1.367	1.367	
W	0.316	0.321		.319	.319	.319	.319	
X	1.125	1.145		1.131	1.132	1.132	1.133	
Y	1.565	1.585		1.576	1.577	1.577	1.578	
Z	0.178	0.198		.188	.188	.188	.188	
AA								
AB								
AC								
AD								
AE								
Accept/Reject								

Measured by: J.L. Lmk	Date: 08/11/07
Audited by: 88	Date: 08/11/11
Prototype Approval: N/A	Date: N/A

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	42886
Description: 206 Saddle, Inboard, Left side		Part Number:	D2933-1
Inspection Dwg: D2933 Rev: C DSK: Rev:		Page 1 of 1	

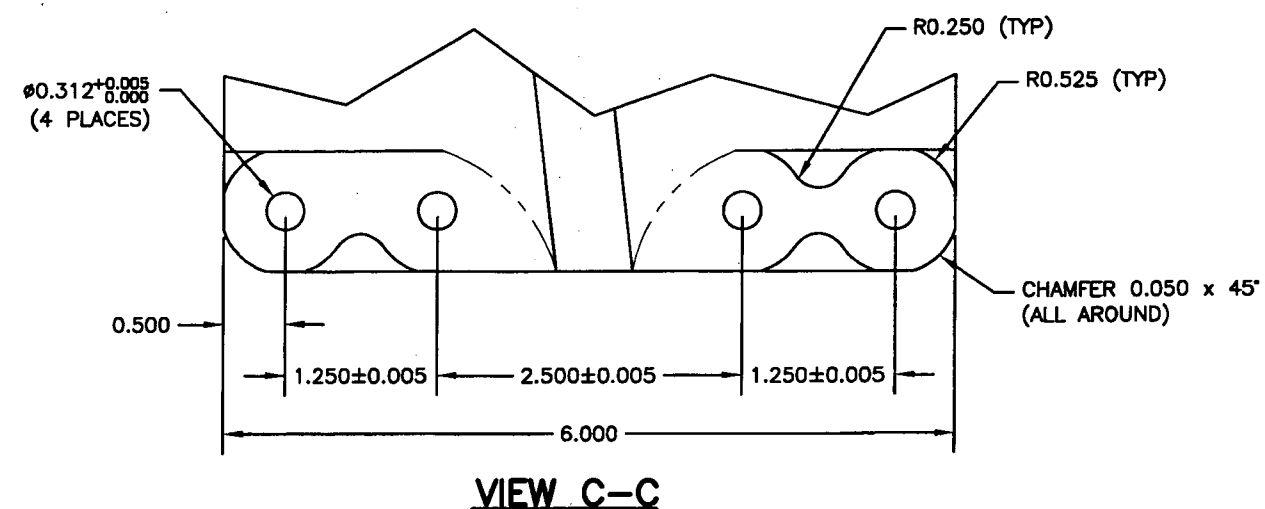
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C	0.100	0.140		.120	.118			
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E	1.245	1.255		1.250	1.250			
F	1.245	1.255		1.250	1.250			
G	2.495	2.505		2.500	2.500			
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K	0.257	0.262		.258	.258			
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R	2.470	2.510		2.492	2.492			
S	0.240	0.270		.253	.254			
T	0.100	0.180		.140	.140			
U	1.625	1.635		1.636	1.630			
V	1.362	1.372		1.367	1.367			
W	0.316	0.321		.319	.319			
X	1.125	1.145		1.132	1.132			
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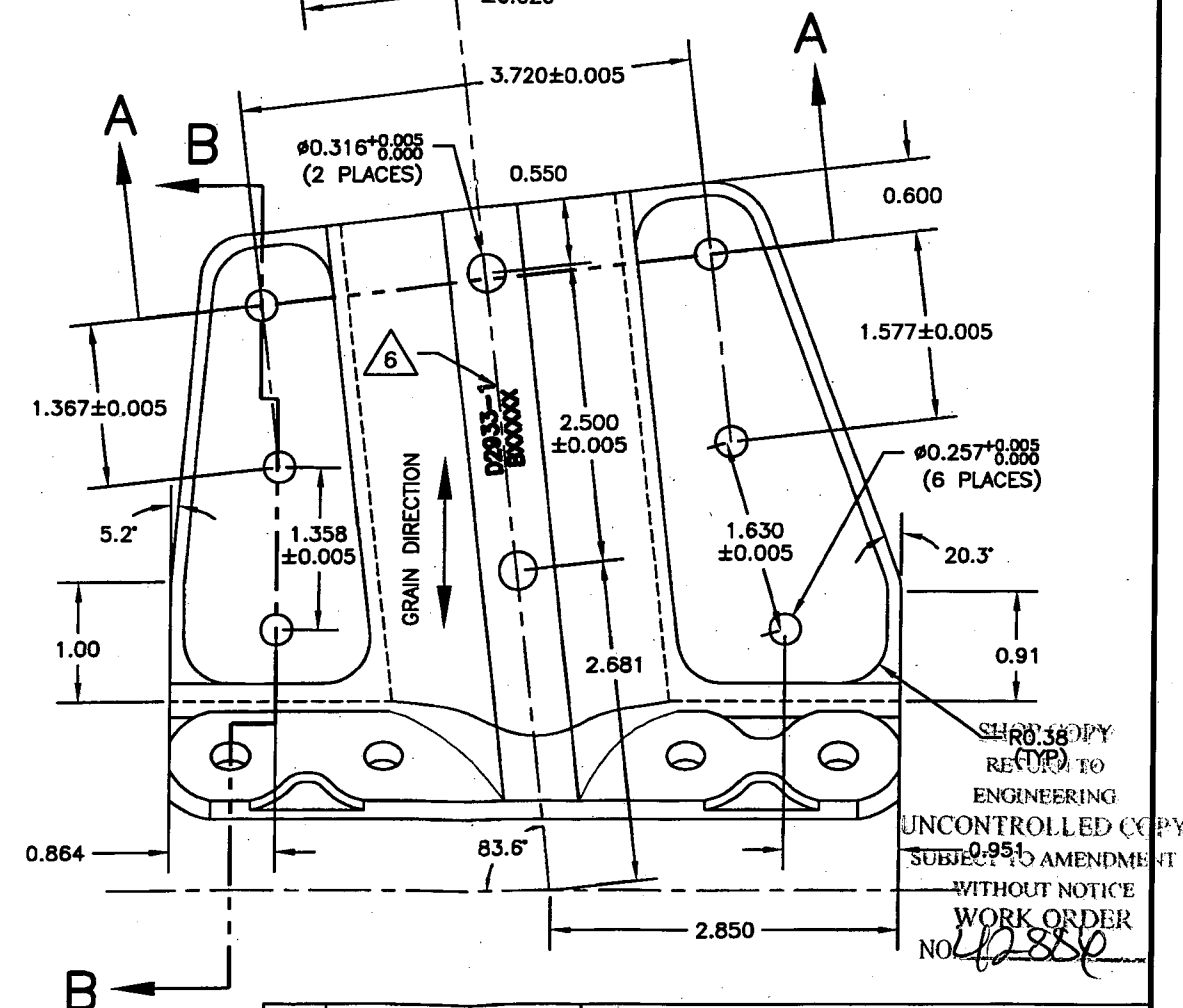
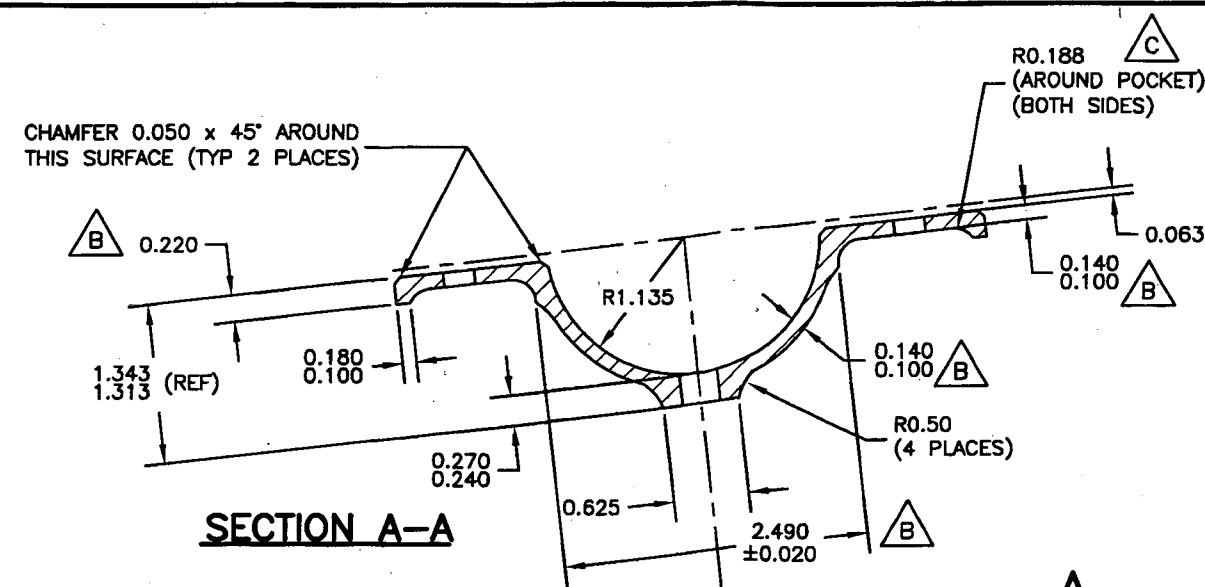
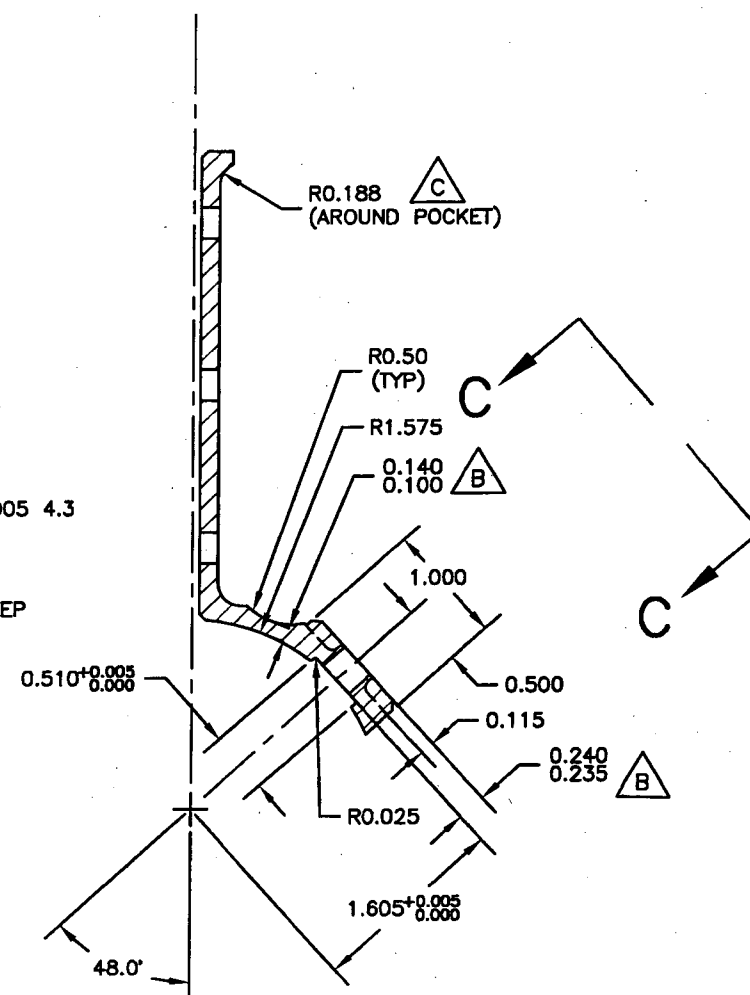
Measured by:	JL PM	Date:	08/11/07
Audited by:	JS	Date:	08/11/11
Prototype Approval:	N/A	Date:	N/A

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D	07.03.21	Revised per drawing revision C	KJ/JLM	
E	08.01.16	DT8695 A/B removed from dimension Y	KJ/EC/DD	DS



D2933-1 LH SADDLE (SHOWN)
D2933-2 RH SADDLE (OPPOSITE)

- NOTES:**
- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-001 SADDLE BILLET, 7075)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
 - 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
 - 5) ALL DIMENSIONS ARE IN INCHES
 - 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP



SHOOT COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 42886

C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN	PH	DRAWN BY CB
CHECKED	PH	APPROVED
DATE	06.11.09	TITLE
		SADDLE INSIDE
		REV. C
		SHEET 1 OF 1
		SCALE
		2:3

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 OR COPIED OR COMMUNICATED TO ANY OTHER
 PERSON WITHOUT WRITTEN PERMISSION FROM
 DART AEROSPACE USA, INC.

DART DART AEROSPACE USA, INC.
 BELLEVUE, WA

DRAWING NO. D2933
 TITLE SADDLE INSIDE
 REV. C
 SHEET 1 OF 1
 SCALE 2:3

RELEASED
 07.02.12

